

Date: Wednesday, 25/03/2009 1:38:32 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 407 STEP ASSEMBLY
Job Number : 46698	
Estimate Number : 11798	
P.O. Number :	Part Number : D206628034
This Issue : 25/03/2009 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run : 42143	Material :
Written By :	Due Date : 08/04/2009 Qty: 5 Um: Each
Checked & Approved By : <u>JUD 09-03-05</u>	
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM Est Rev:E as per ecn 1118 08-02-05 DD verified by:EC est rev F ncr 09-004 09.01.09 EC verified by:DD	

Additional Product

ECN 1118 DSI 9332

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 09/04/24



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-034 CHG 0023

DSI 9332 inc. generated

(P10)

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	46698A	FLOAT STEP ASSEMBLY RH (206/407)
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Comment: Sub-Component 206B STEP ASSY, LH

1 x D2842-042 Batch 46698

JUD 09/04/20 RS

4.0	D2732	Rubber Extrusion
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✓ (DSI)



Comment: Qty.: 2.0000 f(s)/Unit Total: 10.0000 f(s)

Qty	Part #	Description	Batch
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8	D2732	RUBBER CUSHION	<u>B43313</u> <u>B38509</u>
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CUT EIGHT PIECES 3.00" LONG

measured 8/14/20

JUD 09/04/20 RS

5.0	D27313	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

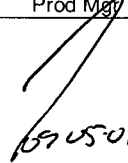
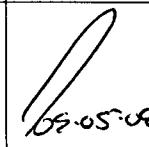
Pick:

Qty	Part Number	Description	Batch
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4	D2731-3	Mounting Lug	<u>B39441</u> <u>x 10</u>
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B43313 x4

JUD 09/04/20 RS

W/O: 46698		ESTIMATE: 11798		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-05-08	1.0	chg to chg 003 per DSI 9332 is incorporated into the W/O. Perm change.				 09-05-08	 09-05-08	

Part No: D206-628-034 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 407 STEP ASSEMBLY

Job Number: 46698

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28441

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 D2844-1 Arm

39542 x2 B47728 x8 SS 09/04/2005

7.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2844-3 Arm

B37338 x5 B47729 x4 SS 09/04/2005

8.0

D3394041

Lug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D3394-041 LUG ASS.Y

B42232 x6 B46861 x14 SS 09/04/2005

9.0

AN4C14A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN4C14A Bolt

M67087 x8 M110105 x32 SS 09/04/2005

10.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN3C4A Bolt

M111424 SS 09/04/2005

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C15A Bolt

M110155 SS 09/04/2005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date:
User:

Wednesday, 25/03/2009 1:38:32 PM
Julie Dawson

Process Sheet

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Drawing Name: 407 STEP ASSEMBLY

Job Number: 46698

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 15.0000 EACH(s)

Pick:

Qty Part Number Description Batch

3 AN960C10 WASHER

Batch M109105

13.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 120.0000 Each(s)

batch:

M111279 x 108 M111127 x 12

14.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 NAS1515H4L Washer

Batch M1107008 M1111359 x

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4 Nut (or MS21042-4)

Batch M111424

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 NAS1515H3 Washer

Batch M109268

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6505.08 5
Kits packaged.

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-034

Location: D

19/03/08 U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

PPP Rev: _____

19.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/11 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

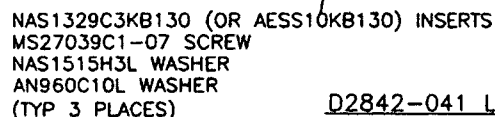
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. 8
CHECKED 	APPROVED 	DRAWING NO. D2842		SHEET 1 OF 1
DATE		TITLE	SCALE	



NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C 10I	WASHER

TYPICAL STEP END DETAIL
NOT TO SCALE

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

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